Work Orde April-11-13 2:5		719		*997	719*						Page 1
Item ID: Revision ID:	D4020-5		,	Accept	*N900	040	100)* s	Setup Star	1.77	S1*
Item Name:	Mesh (350 Bas	sket Long, Lid)							Stop	, *N	S2*
Start Date:	4/11/13	Start Qty: 1.00	*1*		Cust Item II	D:					
Required Date:	4/11/13	Req'd Qty: 1.00	*1*		Customer:						
Reference:								_	ė.		
Approvals:	Process Pla	n: MLJ	Date:\3-04-15	Tooling:	Da	ıte:		ŀ	Run Star	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ıte:			Stop	° *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D4020	A										
100				0.00	Λ)		
100		FLOW WATER JET			COL 13.5.6	مر		(6x)	/ 		
Shear		Memo	D 04030	0.00	CIL 13:30						
Shear			r Dwg D4020 · label will be cut when insta	ll on lid (D3914-041)							
110		QC6- Inspect dimension	s to drawing	0.00	•				. 0		
110									IH	13.05	.06
QC		Memo		0.00						, -	
Quality Control											
120 *120*		Identify as per dwg & St	tock Location: WA 7	0.00 CX1	3.5.6			16x			
Packaging Packaging		Memo		0.00					·		

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Closed:	Date:	

									QA Closed:	Date	:
Work Orde	eń:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other	
Root			T	Descr	ption of work order update	Initial	Α	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											
Unapproved		<u>.l</u>	<u> </u>	<u> </u>		1117.64	TECODY .			<u> </u>	_!
					 	AULT CA	IEGURY				. <u> </u>
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Inspections of the control of the co	ware ection Incomplete uctions Incomplete ntenance ubeled ead et of Calibration	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	⊢ — 1	Sequence wist in Tu		-	Finish Folio	\vdash	of Sequence ide Dimensions				

Work Orde April-11-13 2:5		9719		*997					Page 2			
Revision ID:	D4020-5 Mesh (350 B	asket Long, Lid)	-	Accept	*N900040100				Setup	Start Stop		S1* S2*
Start Date: 4/11/13 St		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Reference:				•					_	. .		
Approvals: Process Plan:		an:	Date:	Tooling: SPC (Y/N):		Date:Date:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description OC21- Final Inspection	Work Order Delegge	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject lumber	Insp. Stamp

0.00

Memo

130

Quality Control

NBB.7

3.1

NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPE	DATE	OA Clasadi	Date	٥.
<u>.</u>						DISPOSITION				AGAINST DE	QA Closed:		<u>. </u>
Work Orde	er: _					<u> </u>	.			_	· .	_	
						Rework	1		Skid-tube	Crosstube	_	Water Jet	Engineering
Part N	No					Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
NCD A	\					Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	vo					Work Order Update]		Large Fab	Composite	j	Supplier	_
Root	Т				Descri	ption of work order update		Initial	Act	ion	Sign &		,
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data	\Box												
Equip/Tooling	П												
Operator						•							
Material													
Setup													
Other	\Box		•										
Process	П					1							
Supplier	П												
Training													
Unapproved							1						
						F	AUL	T CATE	GORY				
Landi	ng G	ear			_	General	_	•		_	, ·	-	
	-	Bending				Bend	$ldsymbol{le}}}}}}$	Grain		<u> </u>	Ovalized	Ĺ	Pressure/Forced
	Ц	Centre No	ot Conce	ntric to (o/s	BOM/Route		Hardwa			Over/Under	F	Temperature/Cure
	Цí	Cracks				Broken/Damaged	<u>_</u>	4	on Incomplete		Part Incorred	-	Weld
	Щ	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	\Box	Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V		_
	\bigsqcup	Inspection	n Strip in	Tube		Cut Too Short		Misread	!		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset				<u> </u>	
	[].	Torque M	laves in S	Evtrucio	, [Drawing		Out of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

99719

Parent Item:

D4020-5

Parent Item Name:

Mesh (350 Basket Long, Lid)

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by:EC

verified by:EC

EC	IPP Rev:B	as per dwg revA	10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	·	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	834.4941	14.386	15.143158	G	el 13:5	6
				Location		Loc Qtv	Lo	c Code	· M	112545"	7	- G	0.86
				MAT		611.3096843						, (
					125113	611.309684							
				WA		121.0000637							
					124070	0.00006372							
					124466	121							•
				WA007		102.18437							
					122534	32.61937							
					123448	, 15.96							
					124347	53.605							

											DQA:	Da	te: _		
NCR:	es/	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UPD	ATE	·				
						1					QA Closed:	Da	te:		
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIR Old	-''-			-		Rework			Skid-tube	Crosstube		Water Jet		Engineering	
Part N	۱o.					Scrap		•	Machining	Small Fab	Prod. Eng. Coor.			Quality	
`NCR I	NCR No.				·	Use-as-is Work Order Update	Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Supplier			Other		
Root		_			Descri	ption of work order update		Initial	Acti	on	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verificatio	n	QC Inspector	
Doc/Data															
Equip/Tooling			1												
Operator															
Material					1										
Setup							İ								
Other					<u> </u>		ļ						.		
Process			ļ												
Supplier															
Training							ļ								
Unapproved															
						F <i>i</i>	AUL	LT CATE	GORY						
Landi	ng (Gear				General		-			1				
		Bending				Bend		Grain			Ovalized		—	Pressure/Forced	
:		Centre N	ot Conce	ntric to	o/s	BOM/Route	Ŀ	Hardwa	re		Over/Under	tolerance	⊢	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete	<u></u>	Part Incorred	t	$oldsymbol{oldsymbol{\sqcup}}$	Weld	
,		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	∐\	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved				
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	/rong			
	Γ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	Í		Power Loss/Surge			Other	
Ripples in Bend						Drill Holes	Г	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

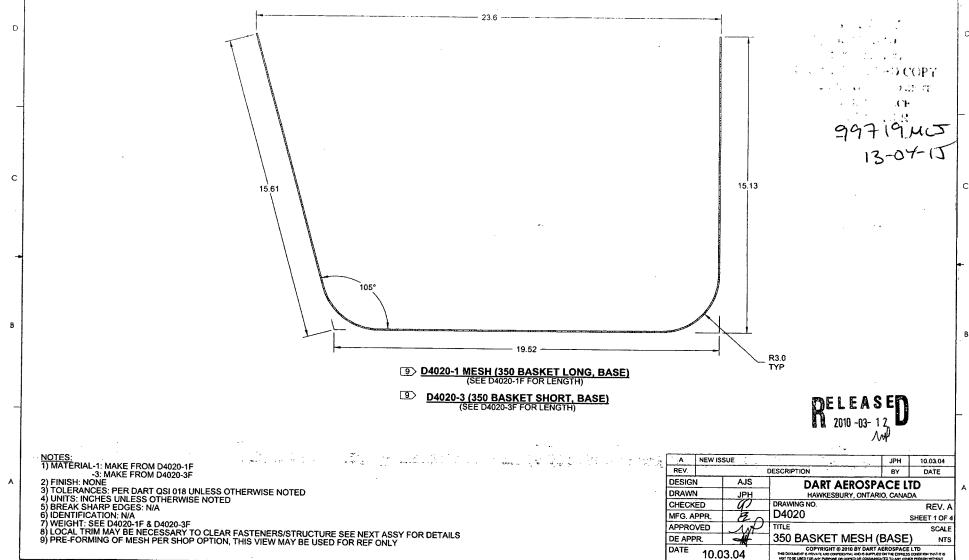
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio



CHECKED MFG. APPR. APPROVED TITLE DE APPR.

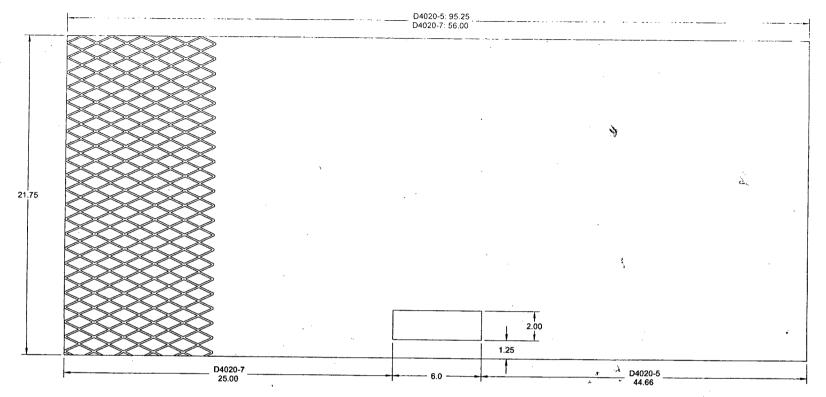
D4020

350 BASKET MESH (BASE)
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DATE 10.03.04

SHEET 1 OF 4

SCALE



D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	9	DRAWING NO. REV. A					
MFG. APPR.	E	D4020 SHEET 2 OF 4					
APPROVED	UMP.	TITLE SCALE					
DE APPR.	-14	350 BASKET MESH (BASE) NTS					
DATE 10.	03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CORPORATIVE AND IS SPPUED ON THE DOTRESS CONDITION THAT IS NOT TO BE USED FOR ANY PURPOSE OF GOVERN ADMINISTRATION OF ANY PURPOSE OF A COMMANDATED TO ANY OTHER PERSON WITHOUT WHITTEN DEPAISSON, WITHOUT ANY ARROPMORE LTD.					

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 ibs APPROX
-7: 4.49 ibs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

0.40 R1.44 REF 15.50 2.00 0.38

9 D4020-11 END MESH, BASKET

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 Ibs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR EASTENEDS/STRUCTURE

7) WE COLL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS \pm 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE)

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R3.38 2 PL

